

Date: Wednesday, 7/12/2006 3:23:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOW FLOAT STEP ASS'Y RH AIRCRUISER
Job Number : 27870A	COMPATIBLE
Estimate Number : 11854	
P.O. Number :	Part Number : D2356042
This Issue : 7/12/2006 S.O. No. :	Drawing Number : D2356 REV DYE E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : DYE E
Previous Run :	Material : 8
Written By :	Due Date : 8/15/2006 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est D 00.06.26 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2244116

Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

1 D2244

Step Extrusion

B23404

+4 6x32.8 216

LE. 07.02.14
 LE. 06.08.15

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE.1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2356-2 from D2244 extrusion as per Dwg D2356 using cutting table setup DT 8185-L

Drill D2365-2 as per Dwg D2356 using Jig DT 8230 a.m 07.07.23 (6)

Bend per Dwg D2356 using Bend Program D2356.2D and Folio FT012

Deburr and bevel ends for welding a.m 07.07.23 (6)

DEL 7-4-3 (7)
 EL 7-7-23 (6)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number

Description Batch



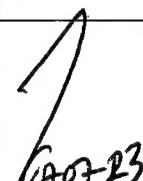
1 D2673-34

End Cap

B32404

LE. 07.07.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27870A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/07/23	2.0	1 scrap. Step has a major kink on the side, from the raw extru- sion, i made kink did not remove during bending. 1 step scrap, over bent. Operator error.	 asiar2	Re/tee both and scrap and destroy scrap parts.	EZ 7-7-23	Ep 07/07/23	 asiar2	 07/07/23

Part No: D2356-042 PAR #: N/A Fault Category: Prod. - LG NCR: Yes No DQA: HA Date: 07.08.17

NOTE: Date & initial all entries QA: N/C Closed: HA Date: 07.08.21

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW FLOAT STEP ASS'Y RH AIRCRUISER COMPATIBLE

Job Number: 27870A

Part Number: D2356042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D28491

End Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

End Bracket

Pick:

Qty	Part number	Description
1	D2849-1	Bracket

Batch

39423

SE 07-04-11 7

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and bracket as per Dwg D2356 using Jig DT 8033

Grind end cap weld flush Remove all sharp edges from weld on bracket

See sample DT 8245

SE 01-01-25 7

7.0

QC5/9

WELD INSPECTION



Comment: WELD/WORK INSPECTION

Q.A. 07-07-28 7
70225 (7)

07-07-28 7
01-07-25 (7)

8.0

D26431

Lo Skid Step LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Lo Skid Step LH

Pick:

Qty	Part Number	Description
1	D2643-1	Lo-Step Leg Ass'y

Batch

39724 or 316928

SE 07-07-24 7

9.0

D26432

LO SKID STEP RT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

LO SKID STEP RT

Pick:

Qty	Part Number	Description
12	MS20600AD4W3	Rivet

Batch

316929

SE 07-07-26 7

10.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 12.00000 Each(s)/Unit Total: 48.00000 Each(s)

Cherry Rivets

Pick:

Qty	Part Number	Description
12	MS20600AD4W3	Rivet

Batch

M18071

SE 07-07-26 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/12/2006 3:23:03 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW FLOAT STEP ASS'Y RH AIRCRUISER COMPATIBLE

Job Number: 27870A

Part Number: D2356042

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet as per Dwg D2356

07-07-27 7

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QC5 En 07/07/30 (47)
QC9 M 07/07/30 (7)

POWDER COATING

POWDER COATING

13.0B



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/M-07-08-14

(7)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2356 and QSI 005 4.4

m/04942

07/08/14 (7)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

En 07/08/15 (47)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

R.P.P 27870 7/8/15 sq

7X1

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07.08.17

Job Completion



07.08.16

13.0A

Acid etch & alodine per QSI005

a.m 07.07.26

02

(7)

BR/H 07-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2356	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE LOW FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.16	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.10.13	CHANGED TO BEND, D2849 REPLACES D2358 & D2359, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2356 LOW FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2356-041	Low Float Step Assembly (LH)	X	
D2356-042	Low Float Step Assembly (RH)		X
D2244-52.7	STEP EXTRUSION*	1	1
D2643-1	STEP LEG ASSEMBLY	1	1
D2643-2	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2849-1	END BRACKET	1	
D2849-2	END BRACKET		1
MS20600AD4W3	RIVETS	12	12

*cut per drawing

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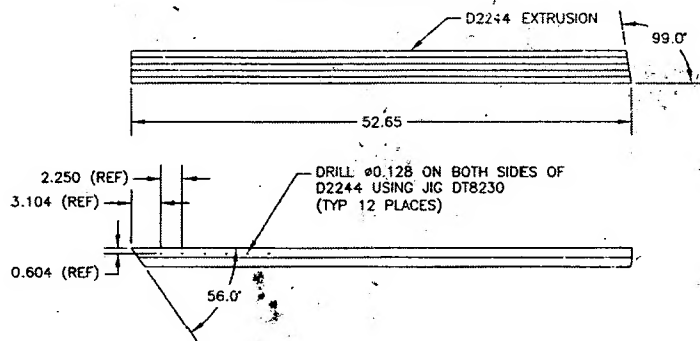
WORK ORDER
NO. 27870A

RELEASED
05.11.28 [Signature]

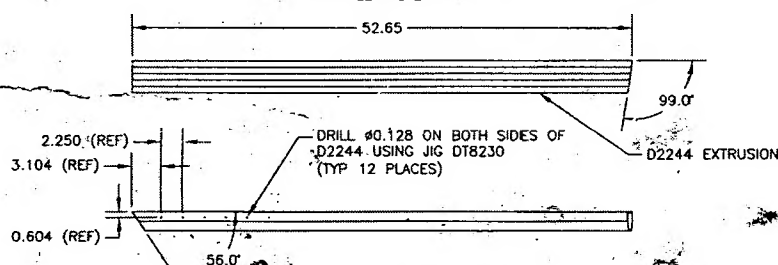
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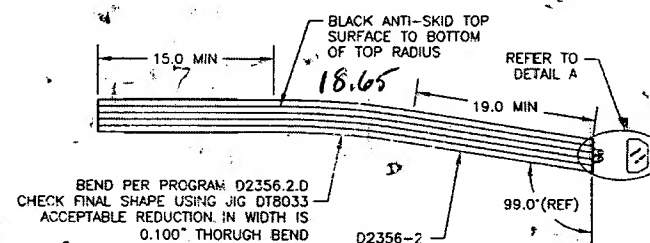
D2356-2 CUTTING/DRILLING DETAIL
RIGHT STEP



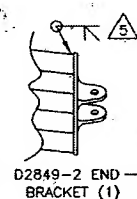
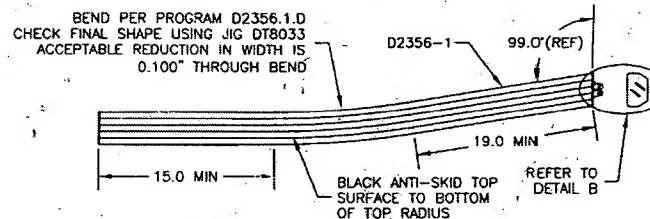
D2356-1 CUTTING/DRILLING DETAIL
LEFT STEP



D2356-042-BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2356-041 BENDING/ASSEMBLY DETAIL
LEFT STEP

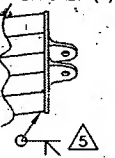


D2849-2 END
BRACKET (1)

DETAIL A
SCALE: 1:4

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WORK ORDER
271870A

D2849-1 END
BRACKET (1)



DETAIL B
SCALE: 1:4

GENERAL NOTES

- 1) WELD PER DART-QSI 004
- 2) FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2849-1 OR D2849-2 IN PLACE. DO NOT GRIND FLUSE.

D2643-1 STEP LEG ASSEMBLY (1)

D2673-34
END PLATE (1)

RIVET D2643-1-2 TO D2244 USING
MS20609 D2643 RIVET (TYP. 12 PLACES)
0.250 (REF)

RELEASED
05.11.18

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
BW	04		
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2356	SHEET 2 OF 2
DATE		TITLE	SCALE
05.11.14		LOW FLOAT STEP ASSEMBLY	1:12

